



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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PRELIMINARY ISSUE

650.9610

Job Sheet 211097



NEED
RECALL

POSITIVE
RECALL

Part No: 650.9610

Job Qty: 5 pcs

Part Name: Electric Valve Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/15/20

Type: SOLD

Description:

Note: DWG 650.9600 REV PB1 IPP REV A 20.06.24 NEW ISSUE FK VERIFY DD

Ship Via:

139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	SL-2500Y - 1	5 pcs		7/7/20	1.00	1.67	SL-2500Y - 1	
110	QC 2	5 pcs		7/7/20	0.00	0.00	QC 2 - 1	



Container No: S290140



Part: 650.9610

Job No: 211097

Serial No/Batch: S290140

Revision: REV - PB1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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www.dartaerospace.com

Date: 07/28/20

P.T.O.

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
112	HAAS 5 Axis - B4B	5 pcs	7/8/20	0.75 10.00	HAAS - 1 - 5 - B4B
					HAAS - 2 - 5 - B4B
114	QC 2	5 pcs	7/8/20	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
					QC 2 - 66
					QC 2 - 64
					QC 2 - 65
					QC 2 - 5
					QC 2 - 71
					QC 2 - 73
					QC 2 - 69
					QC 2 - 76
					QC 2 - 86
					QC 2 - 83
120	QC 8	5 pcs	7/8/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45

					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 81	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Outsource - 17 - Passivate	5 pcs	7/15/20		GRO002-VC	5
140	Packaging 2-1 - Recelve - B4B	5 pcs	7/15/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 37 - B4B	
150	QC 6	5 pcs	7/15/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
					QC 6 - 82	
160	Packaging 3-1 - Stock - B4B	5 pcs	7/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	



				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170	QC 21 - SA	5 pcs	7/15/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9

Part Op 100 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD318 FOLIO REV:
 Descriptions: AA DWG REV: B3 2-Debur
 110 - QC2- Inspect parts off machine FAI/FAiB
 112 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD318 FOLIO REV:
 DWG REV: _____ 2-Debur
 120 - QC8- Inspect parts - second check
 130 - Issue P/O: _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of
 Conformity is required
 140 - Certificate of Conformity is required
 150 - QC6- All purchased or subcontracted products
 160 - Identify as per dwg & Stock
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.750	303 Round Bar 2.750"	5 ft (1 ea)	100-SL-2500Y - 1	S 289 696

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M303R2.750	5	0	0

Part Specifications

Specifications could not be found.

Plex 7/3/20 11:44 AM Dart.lajeunesse.marie

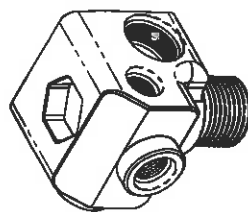
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF DART AEROSPACE DBA AFICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE DBA AFICAL INDUSTRIES IS PROHIBITED.

NOTES:

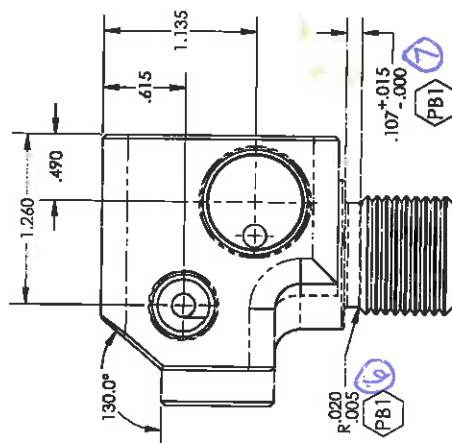
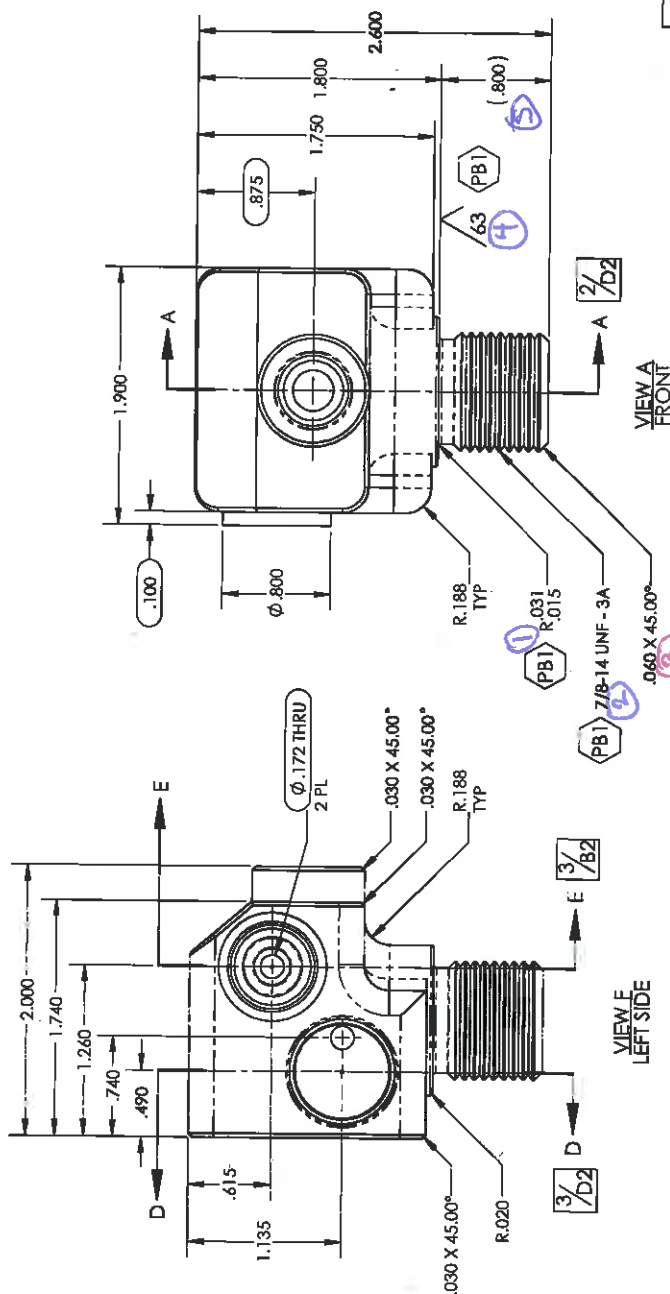
- 1 MATERIAL: 303 SS IAW AMS-5640
- 2 DEBURR AND BREAK ALL SHARP EDGES
- 3 IDENTIFY IAW MPP-120
- 4 USE THREAD SIZE 3/4-28 UNF-2B
- 5 FINISH ∇ MAX UNLESS OTHERWISE SPECIFIED
- 6 ALL THREAD DEPTHS ARE MINIMUM
- 7 (PB) FINISH: PASSIVATE IAW MPP-172 SECTION 6.1.

PROTOTYPE REVISIONS		DATE	APPROVED
ZONE	REV	DESCRIPTION	
ALL		REMOVED ±.005 TOLERANCE	
B-1-1		REMOVED ELECTROPLISH FINISH	
C-1-1		ADDED R.015-.031 DIMENSION	
C-2-1		ADDED SURFACE ROUGHNESS VALUE	
C-3-1		ADDED R.005-.020 DIMENSION	
C-4-1		ADDED R.015-.020 DIMENSION	
D-3-1		DIMENSION WAS .114 IS .107±.015/-0.000	
D-4-1		THREAD CLASS WAS 2A IS 3A	
B-1-2		ADDED .250 2 PL DIMENSION	
		DIMENSION VALUE OF .734 DIMENSION	
C-2-2		ADDED SURFACE ROUGHNESS VALUE	
D1-2		DIMENSION WAS .0092±.003	
D-2-2		DIMENSION WAS Ø .300±.005 IS Ø .300±.006/-0.001	
B-3-3		ADDED ALL AROUND TO DIMENSION	
		ADDED R.010 2 PL DIMENSION	
B-3-3		DIMENSION WAS .0075±.001	
		ADDED SURFACE ROUGHNESS VALUE	
B-6-3		ADDED .084-.089 DIMENSION	
		DIMENSION WAS .050±.002 IS .050-.054	
		ADDED SURFACE ROUGHNESS VALUES	
B-7-3		ADDED SURFACE ROUGHNESS VALUE	
	PB1		
		06/01/2020	T. CROSS

REV.	REVISIONS			DATE	APPROVED
	N/C	DESCRIPTION			
A.		INITIAL RELEASE		04-23-16	P. BRAVO
		INCORPORATED RCM 00016		04-21-16	P. BRAVO
B.		INCORPORATED RCM 00046		08-12-16	P. BRAVO



650.9610

[illegible]

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

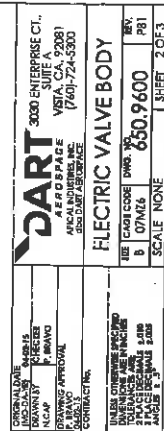
WITHOUT NOTICE

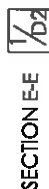
WORK ORDER

NO. 211097 MC

30703

4



[illegible]

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: <u>211 097</u>		DEPARTMENT/PROCESS	
Part No. <u>650-9610</u>		Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Prod. Eng. Coord. ☒ Water Jet ☐ Large Fab ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐	
Date: <u>20-08-13</u>		MIRB (QS1042) DAS 9 9-89 20-8-13	
Sequence #: <u>110</u>		Completed By 20 20-08-13 9-89	
Description Work Order Deviation		Lead hand / Supervisor D. 20-08-13	
Blanks were cut to short as a result of what the w.o. demanded. Can not machine cut at 3.000" needed to be cut at 3.300"		fed program to be updated 20-08-13	
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Misaligned/off center ☐ Folio/Program ☒ BOM/Route ☐ Grain Direction ☐ Broken/Damage/Defect ☐ Weld ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Drill Holes ☐ Out of Sequence ☐ Fit/Function ☐ Off-set/Set-up ☐	
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:			

PART AEROSPACE LTD		Work Order:	211057
Description: Electric Valve Body		Part Number:	650.9610
Inspection Dwg: 650.9600	Rev:	PB1	Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
①	R.015/.031		.020	✓		opt comp	
②	7/8-14 UNF	3A					
	Mat. Ø.8699"	±.0052	.8702	✓		Mic h P10	
	wire Ø.040"					↓	
	DOW.8847"	±.002	.8849	✓		↓	
③	.060 x 45°	±.005 x .5°	.062 x 45°	✓		Vern h P10	
④	.800	±.005	.800			Vern h P10	
⑤	.005/.020		.015			opt comp	
⑥	.107	±.015/.000	.118			↓	
⑦	Ø.773	±.002/±.003	.773			Vern h P10	
⑧	.025 x 45°	±.005 x .5°	.025 x 45°	✓		↓	
⑨	Ø.625	±.005	.625			Vern L P10	
⑩	Ø.500	±.005	.500			↓	
⑪	.400"	±.005	.400			↓	
⑫	Ø.1105	±.005	.1105	✓		↓	

Measured by: <i>[Signature]</i>	Checked by:	QC Inspector:
Date: 20/07/25	Date:	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	